

Work Order ID 70626

Monday, June 13, 2011 11:05:02 AM



Item ID:	D2421	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bearpaw, 900					
Start Date:	6/10/2011	Start Qty:	4.00		Cust Item ID:	
Required Date:	6/22/2011	Req'd Qty:	4.00		Customer:	

Reference:

Approvals:	Process Plan:		Date:	6-13-11	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2421	Rev F2								

120		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut Blank as per file D2421_BLANK								

B11-6-14

(4)

130		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							

F.K. 11/11/29

4 0

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA124 and Dwg D2421
Identify as D2421
3-Deburr

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID 70626

Monday, June 13, 2011 11:05:03 AM

Page 3

Item ID: D2421

Accept

Revision ID:

Item Name: Bearpaw, 900

Start Date: 6/10/2011 Start Qty: 4.00

Required Date: 6/22/2011 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/12/11

11-12-1
4

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Picklist Print

Monday, June 13, 2011 11:05:10 AM

Page 1

Work Order ID: 70626



Parent Item: D2421



Parent Item Name: Bearpaw, 900



Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 		Purchased	No			120	sf	300.6000	4	16			
UHMW 1" Black													

1311-6-14

Location

Loc Qty

Loc Code

MAT018

300.6

117321

76.6

117738

59

117819

165

117819

64

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DART AEROSPACE LTD		Work Order:	70626
Description: Bearpaw		Part Number:	D2421
Inspection Dwg: D2421 Rev: F2		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.20	+/-0.030	.194	✓		FK-06	Depth gauge
B	0.95	+/-0.030	.945	✓		FK-04	Vern.
C	0.45	+/-0.010	.445	✓		"	"
D	0.07 x 45°	+0.030/-0.010	.07 x 45°	✓		"	"
E	0.69	+/-0.030	.688	✓		"	"
F	0.38	+/-0.010	.381	✓		FK-06	Depth
G	0.44 - 0.47	+/-0.000	.451	✓		FK-04	Vern.
H	R0.25	+/-0.030	.25	✓		rad gauge	
I	0.19 x 45°	+/-0.030	.19 x 45°	✓		FK-04	Vern.
J	23.00	+/-0.030	23.00	✓		FK-05	Tape
K	Ø0.260	+0.005/-0.000	.260	✓		FK-04	Vern.
L	Ø0.93	+/-0.030	.926	✓		"	"
M	0.30	+/-0.030	.319	✓		FK-06	Depth gauge
N	4.50	+/-0.030	4.50	✓		FK-05	Tape
O	9.50	+/-0.030	9.50	✓		"	"
P	1.00	+/-0.030	1.00	✓		FK-04	Vern.
Q	14.750	+/-0.010	14.750	✓		FK-05	Tape
R	0.38	+/-0.030	.377	✓		FK-04	Vern.
S	4.54	+/-0.010	4.54	✓		"	"
T	19.00	+/-0.030	19.00	✓		FK-05	Tape

Measured by: FK	Audited by: J.A	Prototype Approval:	N/A
Date: 11/11/29	Date: 11/11/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10010	KJ/RF	
B	04.11.29	Revised dimension M	KJ/JLM	

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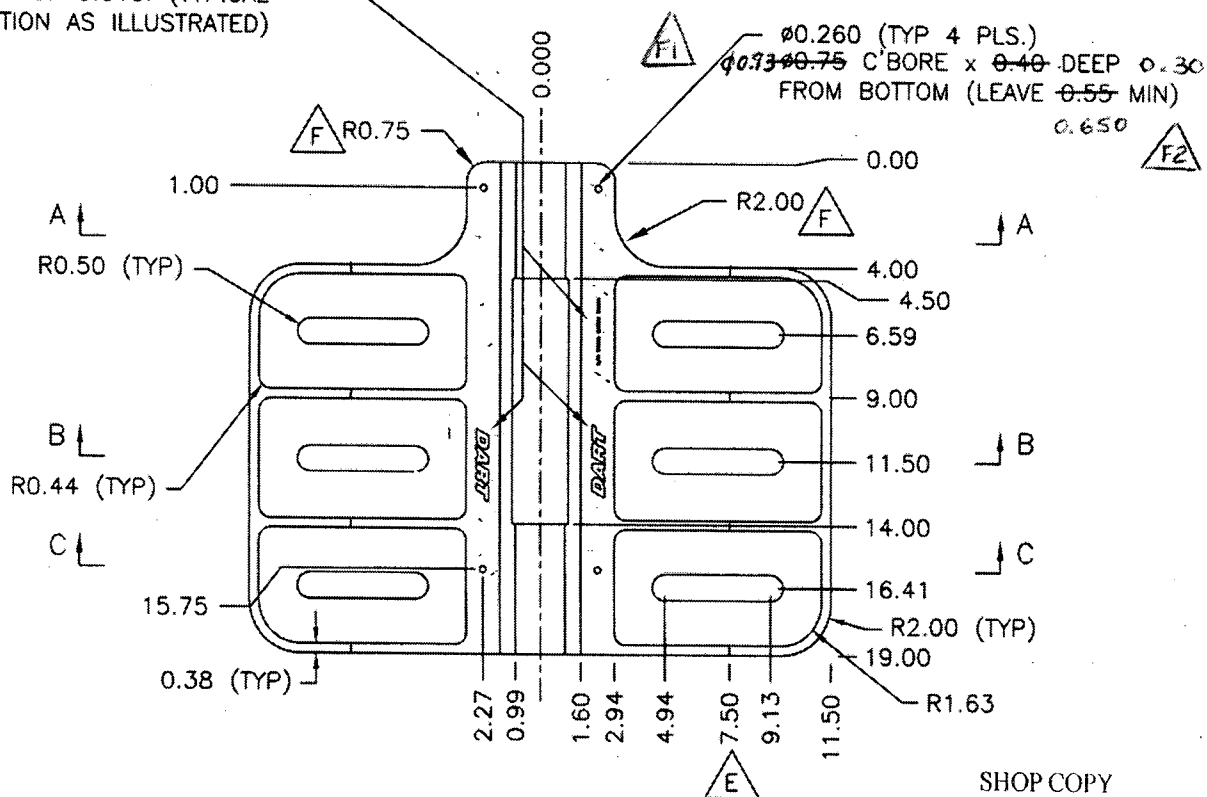
NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RF	APPROVED <i>[Signature]</i>	DRAWING NO. D2421	REV. F SHEET 1 OF 2
DATE 01.03.12		TITLE BEARPAW	SCALE 1:7
A	95.04.24	NEW ISSUE	
B	95.11.28	CHANGED NUMBER OF HOLES	
C	97.06.19	ADDED MATERIAL SPECIFICATION	
D	98.08.11	DIM MODIFICATIONS	
E	00.03.01	R1.77 WAS R2.66; ADD R1.85 BORE RELIEF FOR CLAMPS; ADDED DEO 9155	
F	01.03.12	MODIFY FWD END	
F1	03.01.13	Ø0.93 WAS Ø0.75; RØ.19 WAS RØ.38;	
F2	04.11.03	Ø.30 WAS Ø.40 ; Ø.650 WAS Ø.55	

RELEASED
01.03.14 *[Signature]*

ENGRAVE DART LOGO TO
MAX DEPTH OF 0.012.
ENGRAVE PART AND BATCH
NUMBERS TO MAX DEPTH
OF 0.010. (TYPICAL
LOCATION AS ILLUSTRATED)



SYMMETRIC ABOUT CENTER LINE

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689,
1.00" THICK (MACHINE TO 0.950)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 70626
11-26-13

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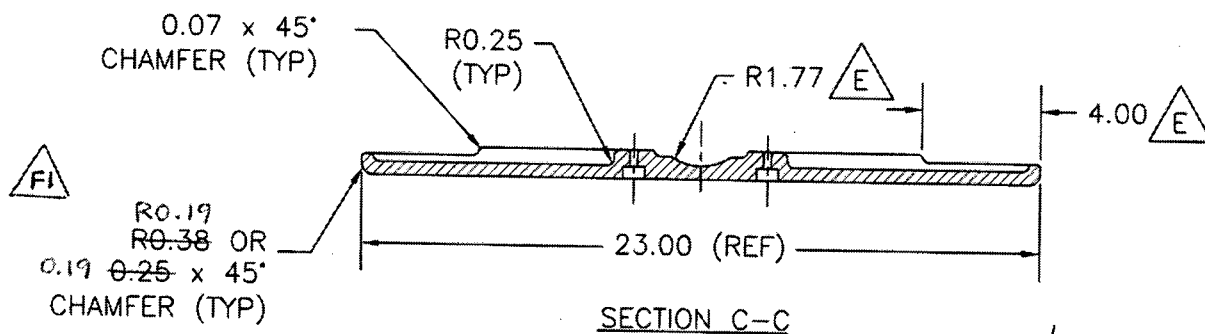
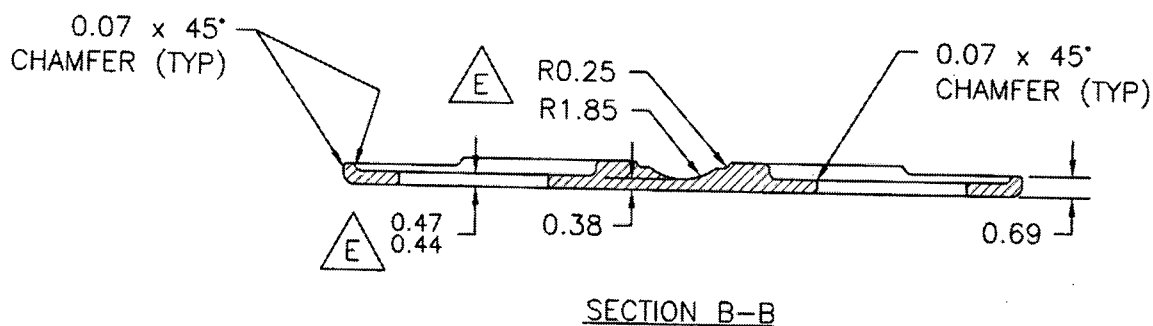
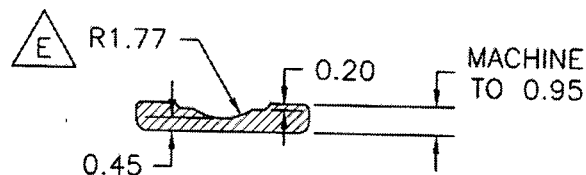
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DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RF	APPROVED #	DRAWING NO. D2421	REV. F SHEET 2 OF 2
DATE 01.03.12		TITLE BEARPAW	SCALE 1:6

RELEASED
01.03.14 #



u/o 70626

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